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(54) MANUFACTURE OF BRASS PLATED STEEL  
 WIRE

## (57) Abstract:

PURPOSE: To provide a method for manufacturing a hard wire for reinforcing rubber articles to which especially fatigue property, adhesion to rubber and corrosion resistance are required.

CONSTITUTION: In a 1st stage to a 4th stage, including the final stage, on the upstream side from the final stage of a wire drawing process, air projecting type shot peening treatment using compressed air is applied to a brass plated steel wire whose diameter is 1-0.4mm and tensile strength is  $\geq 300 \text{ kgf/mm}^2$  and which is manufactured by executing wire drawing with a skin-pass die of 2-10% reduction of area under conditions that shot grain size:  $\leq 200 \mu\text{m}$ , HV hardness of the shot grain:  $\geq 600$  and  $\text{Sp} = 2-100 \text{ kgf/cm}^2 \cdot \text{sec}$  ( $\text{Sp}$  = air jetting pressure ( $\text{kgf/cm}^2$ )  $\times$  shot peening treating time (sec)).

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